

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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111557

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N900040100

Setup **Start** ***NS1***

Stop *NS2*

?

Cust Item ID:

~

Customer:

Reference:

Date: _____

Run Start *NR1*

Date:

Stop *NR2*

**Insp.
Stamp**

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 14-04-03

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Picklist Print

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Page 1

Work Order ID: 111557
 Parent Item: D4148-041
 Parent Item Name: Fwd X-Tube Lug Ass'Y

Start Date: 1/17/14 Required Date: 1/17/14
 Start Qty: 2.00 Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 10.10.29 as per revC
 DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No			100	Each	895.0000	4	4		14/04/02	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				FG		80							
				103691		80							
				GA		4							
				m126741		4							
				ST315		811							
				124555		92							
				m126741		719							
MS21043-4 Nut		Purchased	No			100	Each	639.0000	1	6		14/04/02	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				FG		40							
				104603		40							
				GA		58							
				125807		58							
				ST509		541							
				m127255		541							
D2690-6 Lanyard		Manufactured	No			100	Each	42.0000	1	2		14/04/02	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST004		18							
				110330		18							
				ST014		4							
				102246		4							
				ST020		20							
				110815		20							

M128429

B112556
 (2x)

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Material									
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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Work Order ID: 111557
 Parent Item: D4148-041
 Parent Item Name: Fwd X-Tube Lug Ass'Y

Start Date: 1/17/14 Required Date: 1/17/14
 Start Qty: 2.00 Required Qty: 2.00

D3910-1	Manufactured	No	100	Each	5.0000	1	2	14/04/02	DAS 36 9-89
Crosstube Lug									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST464		5				
			106717		5			B110135	(2)
D4091-1	Manufactured	No	100	Each	10.0000	1	2	14/04/02	DAS 36 9-89
Mounting Lug									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST144		10				
			107990		2				
			109452		8			2	
D4148-1	Manufactured	No	100	Each	1.0000	2	4	14/04/02	DAS 36 9-89
Crosstube Lug Plate, Fwd									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST145		1				
			106002		1			B110067	(12)
								B113269	(32)
D4148-3	Manufactured	No	100	Each	6.0000	1	2	14/04/02	DAS 36 9-89
Stud Receiver, Lower									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST144		6				
			109609		6			B115182	(2x)
D4148-5	Manufactured	No	100	Each	17.0000	1	2	14/04/02	DAS 36 9-89
Eyebolt Stud									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST145		17				
			105616		17			2	
AN3C12A	Purchased	No	100	Each	4.0000	2	4	14/04/02	DAS 36 9-89
Bolt									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST351		4				
			M127743		4			4	

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Page 3

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 Parent Item: D4148-041
 Parent Item Name: Fwd X-Tube Lug Ass'Y

Start Date: 1/17/14 Required Date: 1/17/14
 Start Qty: 2.00 Required Qty: 2.00

AN4C13A Purchased No

100 Each 313.0000

3 6

14/04/02 DAS 36 9-89

Location

Loc Qty

Loc Code

GA 3
 m125978 3
 ST513 250
 m127815 250
 ST514 60
 124805 60

M128429 (6x)

MS17984-C413 Purchased No

100 Each 47.0000

1 2

14/04/02 DAS 36 9-89

Location

Loc Qty

Loc Code

ST332 47
 m126872 22
 m127813 25

2

MS20615-4M18 Purchased No

100 Each 425.0000

8 16

14/04/02 DAS 36 9-89

Location

Loc Qty

Loc Code

ST312 425
 125162 107
 m127580 68
 m127813 250

M128429 (16x)

NAS1149C0332R Purchased No

100 Each 11,506.000

4 8

14/04/02 DAS 36 9-89

Location

Loc Qty

Loc Code

GA 1233
 125654 1233
 st510 10273
 m126319 2373
 m127306 2500
 m127410 3000
 m127831 2400

8

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

January-15-14 1:18:07 PM

Page 4

Work Order ID: 111557
Parent Item: D4148-041
Parent Item Name: Fwd X-Tube Lug Ass'Y

Start Date: 1/17/14

Required Date: 1/17/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R
WASHER

Purchased

No

100

Each

5,314.0000

6

12

14/04/07
DAS
36
89

Location

Loc Qty

Loc Code

GA	2009
m125807	2009
ST292	68
119124	6
121255	7
122441	55
ST510a	3237
m126221	3237

12

January-15-14 1:18:07 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

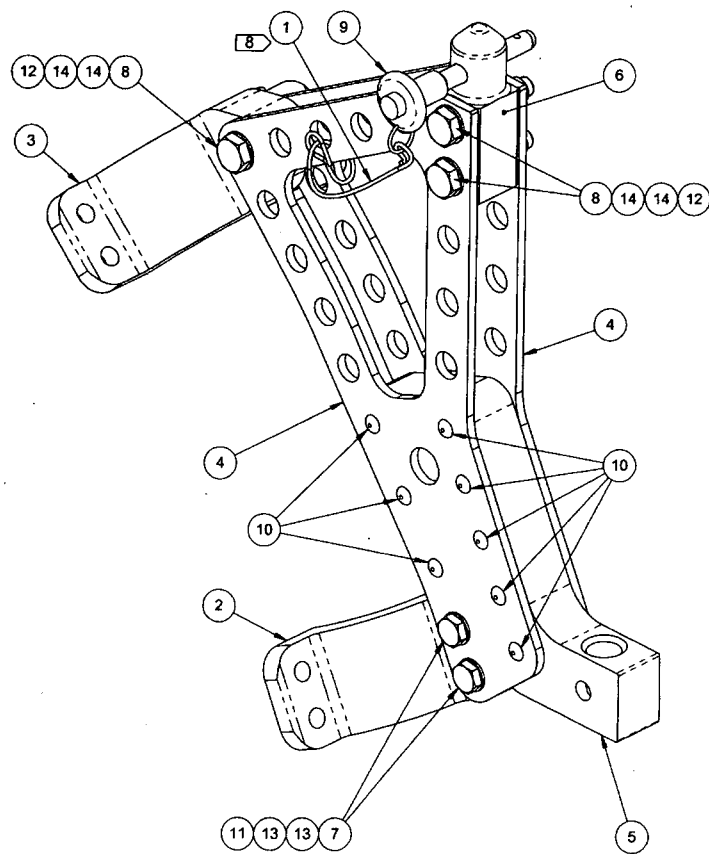
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
 - 7) WEIGHT: 3.66 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIN, QUICK RELEASE
10	8	MS20615-4M18	RIVET, SOLID, PAN-HEAD
11	2	MS21043C3	NUT, SELF-LOCKING
12	3	MS21043C4	NUT, SELF-LOCKING
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

111557 MJS 14-01-16

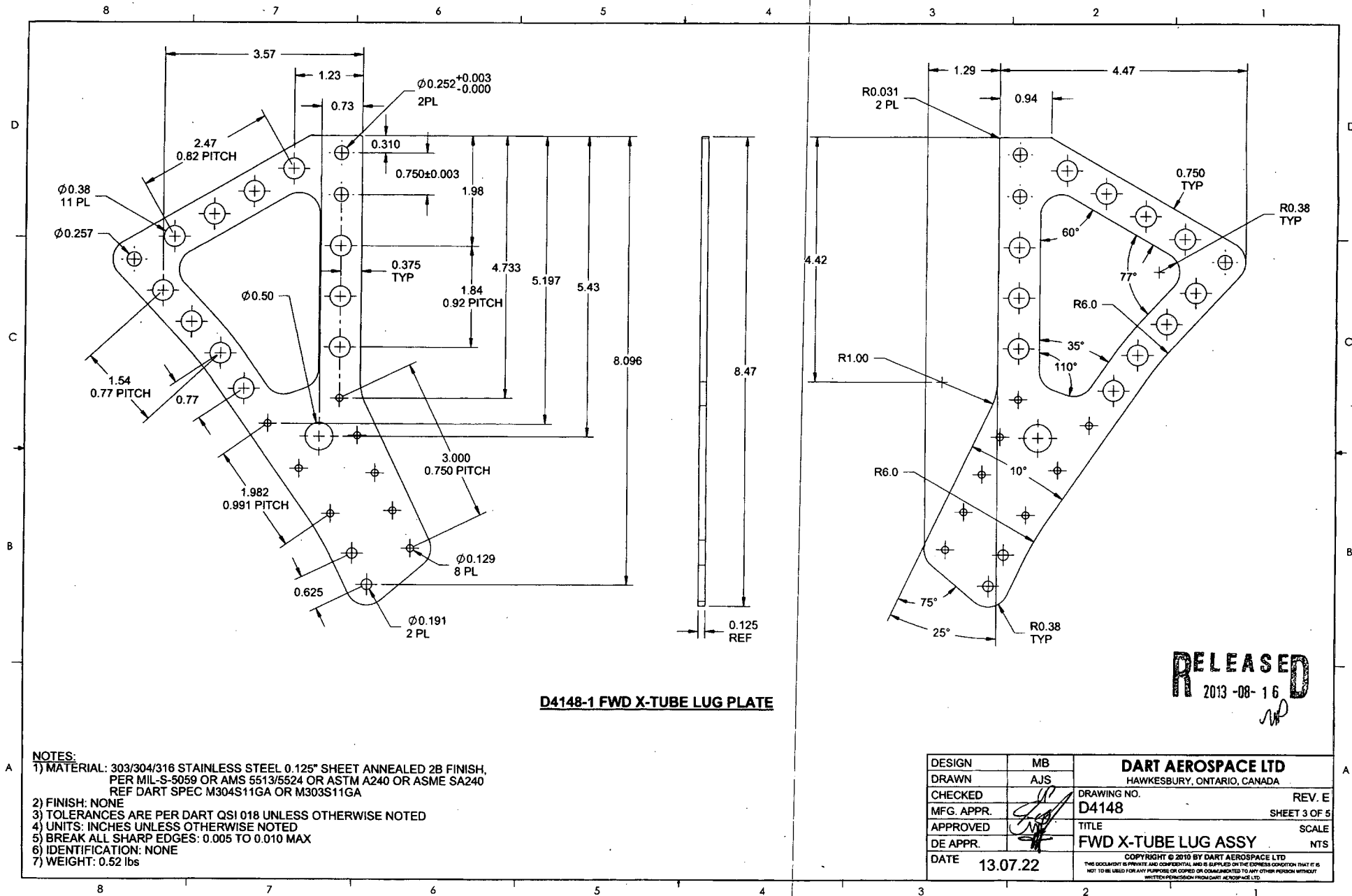
RELEASED
2013-08-16
MP

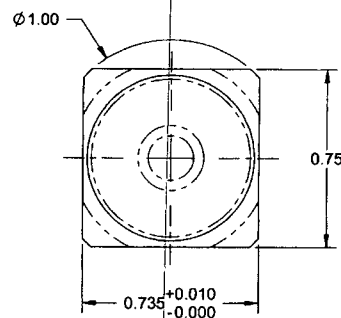
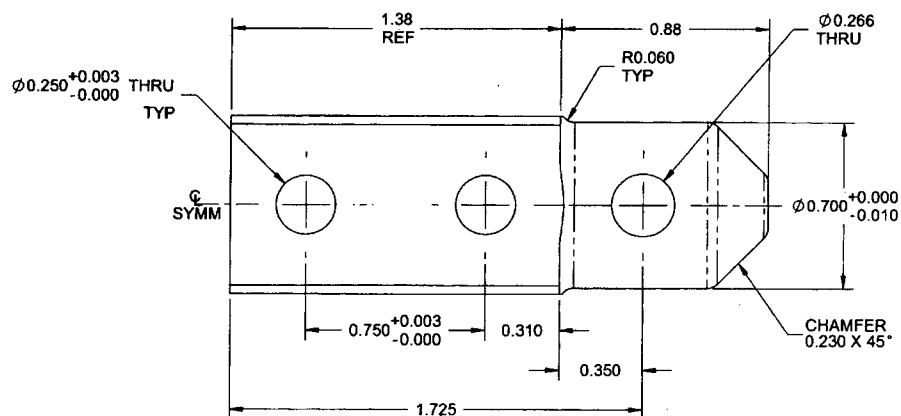
E	B6-4 Ø0.266 HOLE ADDED FOR CARGO TUBE INSTALLATIONS.	AJS	13.07.22
D	HOLE DIA CHANGED TO 0.252" (D6-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-11-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 3 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.181 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. 8.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. D4148	REV. E SHEET 1 OF 5
DATE	13.07.22	TITLE FWD X-TUBE LUG ASSY SCALE NTS	

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8 7 6 5 4 3 2 1









D4148-5 EYEBÓLT STUD

RELEASE
2013-08-16

NOTES:

- NOTES
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4148	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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